

Date: Thursday, 20/11/2008 3:33:32 PM
 User: Julie Dawson

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : COBRA SKIDTUBE ASS'Y
Job Number : 43593	
Estimate Number : 13182	
P.O. Number :	Part Number : D209669013
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D209-669-013
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SKIDTUBES	Drawing Revision : B
Previous Run : 43361	Material :
Written By :	Due Date : 25/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.11.21</u>	
Comment : New est. 08.02.13 LL, verified by:DD	
Est Rev:B 08-05-20 chg QTY of D2570 DD verified by:	

Additional Product

A NEWER
SKIDTUBE SCRAP
9/2/24

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP d209-669-011, CHG002

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick: Packing Kit

3.0	43593A	COBRA SKIDTUBE ASS'Y
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**Comment:** Sub-Component COBRA SKIDTUBE ASS'Y1 x D209-669-043 Batch 43593A SWAP SP

4.0	D2570	Bushing
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**Comment:** Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

24 D2570 Bushing B3980517

5.0	D27361	Lug Assembly, 205 GHW
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2736-1 Bracket B398418/1/26NISP

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 43593

Part Number: D209669013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D27363

Lug Assembly, 205 GHW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2736-3 Bracket B39223

SP

7.0

D29171

Saddle LH



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Saddle LH

batch B43135

SP

8.0

D29181

Saddle LH



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Saddle LH

batch B43137

SP

9.0

D2929

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

batch B43376

SP

10.0

D2930

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

batch B21296

B43378

SP

11.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Ring

batch 42525

8/11/26

AP1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 43593

Part Number: D209669013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN47A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch

M108071

SP

13.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 AN4-46A

Bolt

M108246

SP

14.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch

M108376

SP

15.0

AN536A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch

M109545

SP

16.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

batch

M108827

SP

17.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch

M109282

8/11/20

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D209669013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0	AN9704	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Washer
batch M108928

SD

19.0	MS21042L4	Nut
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Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)
Nut
batch M108145

SD

20.0	MS21042L5	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Nut
batch M108827

8/11/26

1H

SD

21.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

22.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D209-669-013
Location: _____

Adjuster all parts
just Acci
mt 09-02-04

23.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



- Sub was scraped
close @ 0

mt 09-02-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

The following weight and balance information is for the replacement Dart parts. The weight and balance of the skidtubes that are being removed from the aircraft is the responsibility of the installer.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D209-669-011/-012	49.6 lb	170.4 in	8452 in lb
SKIDTUBE INSTALLATION	22.5 kg	4.33 m	97.4 m kg
D209-669-013/-014	43.8 lb	176.5 in	7731 in lb
SKIDTUBE INSTALLATION	19.9 kg	4.48 m	89.2 m kg

5.0 PARTS LIST

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -041	Qty -043	Part Number	Description
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
	1	1			X		D209-669-041/	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)
1A					1		D2906-041	SKIDTUBE ASSEMBLY
1B						1	D2906-043	SKIDTUBE ASSEMBLY
2	1		2				D2917-1	OUTER SADDLE (FWD, LH)
3		1		2			D2917-2	OUTER SADDLE (FWD, RH)
4	1		2				D2918-1	INNER SADDLE (FWD, LH)
5		1		2			D2918-2	INNER SADDLE (FWD, RH)
6	1						D2919-1	OUTER SADDLE (AFT, LH)
7		1					D2919-2	OUTER SADDLE (AFT, RH)
8	1						D2920-1	INNER SADDLE (AFT, LH)
9		1					D2920-2	INNER SADDLE (AFT, RH)
10	8	8	8	8			AN4-51A	BOLT
11	16	16	16	16			D2570	BUSHINGS
12	8	8	8	8			MS21042L4	NUT (OR MS21042-4)
13	2	2	4	4			AN5-36A	BOLT
14	2	2					AN5-41A	BOLT
15	8	8	8	8			AN960JD516	WASHER
16	4	4	4	4			MS21042L5	NUT (OR MS21042-5)
17	16	16	16	16			AN4-7A	BOLT
18	32	32	32	32			AN960JD416	WASHER
19	16	16	16	16			MS21042L4	NUT (OR MS21042-4)

CONTINUED ON NEXT PAGE

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CONTINUED FROM PREVIOUS PAGE

20	2	2	2	2			D2929	SPACER
21	2	2	2	2			D2930	SPACER
*30A					1	1	D3564-9	WEARSHOE (REPLACES D2577-1)
*30B					1	1	D3566-1	GASKET
*31A					1		D3564-15	WEARSHOE (REPLACES 18" D2577-5)
*31B					1		D3566-15	GASKET
*32A					1	1	D3564-11	WEARSHOE (REPLACES D2577-3)
*32B					1	1	D3566-1	GASKET
*33A					1	1	D3564-5	WEARSHOE (REPLACES D2577-5)
*33B					1	1	D3566-5	GASKET
*34					50	44	AN3C4A	BOLT (REPLACES AN3-4A)
*35					50	44	AN960C10L	WASHER (REPLACES AN960JD10L)
*36					50	44	AKS7-1032-130	INSERT (OR ALS7-1032-130, OR ALS4-1032-130, OR AKS4-1032-130)
*37					12	14	D2594-1	PLUG
*38					12	14	D2594-3	O-RING
*40					2	2	D2855	AFT CAP
*41					4	4	AN3-5A	BOLT
*42					4	4	AN960JD10L	WASHER
*43					4	4	AKS7-1032-225	INSERT (OR ALS7-1032-225, OR ALS4-1032-225, OR AKS4-1032-225)
50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	LUG ASSEMBLY
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

* DENOTES THAT PART IS INCLUDED WITH D2906-041/-043 SKIDTUBE ASSEMBLY

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